

Date: Wednesday, 04/02/2009 10:32:51 AM
 User: Julie Dawson

Process Sheet

| | |
|--------------------------------------------------------|--------------------------------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEB |
| Job Number : 45487 | |
| Estimate Number : 10498 | |
| P.O. Number : | Part Number : D2739 |
| This Issue : 04/02/2009 S.O. No. : | Drawing Number : D2739 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SKIDTUBES | Drawing Revision : D |
| Previous Run : 45373 | Material : |
| Written By : | Due Date : 11/02/2009 Qty: 0 Unit: Each |
| Checked & Approved By : <u>JUD 09.02.04</u> | |
| Comment : Est Rev: C 02.11.28 Reformat KJ | |
| Est Rev: D 06-03-21 As Per Rev C JLM | |
| Est Rev: E 07-07-28 As per Rev D JLM | Verified By: |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|-------------------------|
| 1.0 | D26005108 | Extrusion 'I Beam' thin |
|-----|-----------|-------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Extrusion 'I Beam' thin
 Pick:
 Qty Part Number Description Batch
 1 D2600-5 Web B-38589

Acc 9-2-4 (8)

| | | |
|-----|-------------|-----------------------|
| 2.0 | SKIDTUBES 1 | SKIDTUBESS RESOURCE 1 |
|-----|-------------|-----------------------|



Comment: LANDING GEAR RESOURCE 1
 1-Cut D2600-5 to length as per Dwg D2739.
 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
 3-Use uni-bit to open holes to finish size as per Dwg D2739.
 4-Bevel Fwd end of extrusion and Deburr holes and ends.
 5-Dburr

Acc 9-2-4

(8)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

BF 09/02/04

(8)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 04/02/2009 10:32:51 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 45487

Part Number: D2739

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



AUM 9-2-4



(8)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 8 9-2-4

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location:

L-6 AUM 9-2-4

(6)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/05

Job Completion



MF 09-02-05

| W/O: | | WORK ORDER CHANGES | | | | | |
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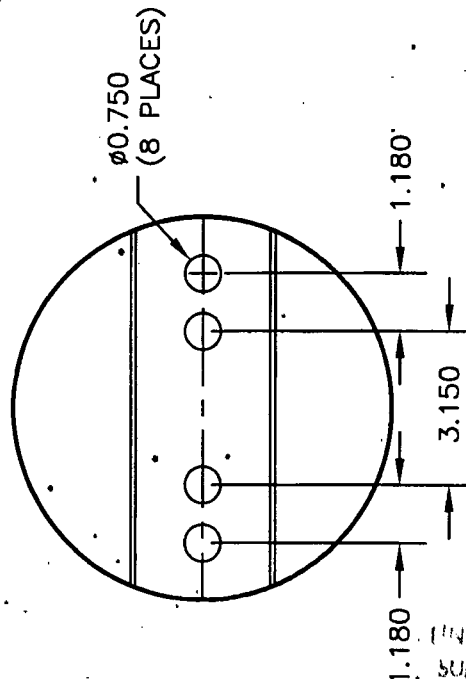
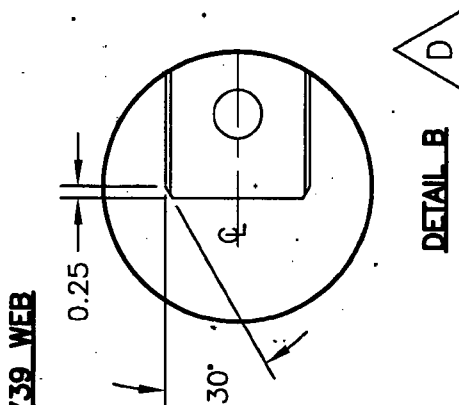
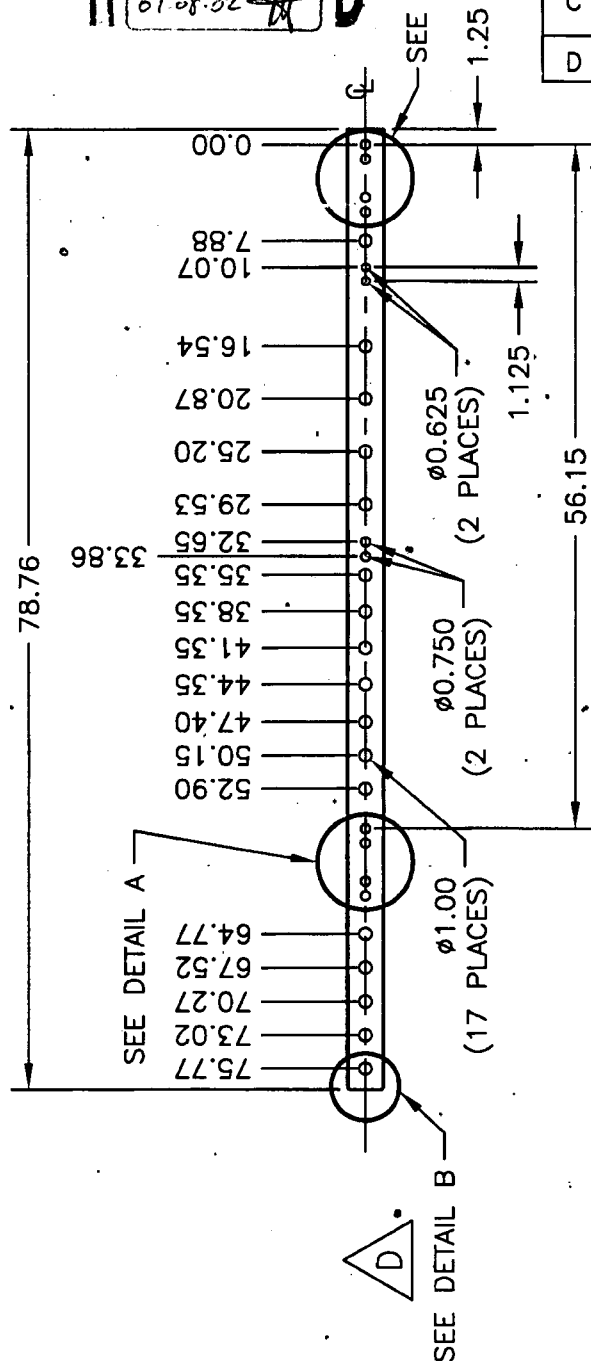
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

RELEASED
07-08-02

| | | | |
|-------------------------|--------------------------------|----------------------------------------------------------|----------------------------|
| DESIGN PH | DRAWN BY CB | DART AEROSPACE USA, INC. PORT HADLOCK, WA | |
| CHECKED PH | APPROVED [Signature] | DRAWING NO. D2739 | REV. D SHEET 1 OF 1 |
| DATE 07.05.29 | | TITLE WEB | SCALE 1:15 |
| A | 98.04.16 | NEW ISSUE | |
| B | 98.11.18 | CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS | |
| C | 06.01.05 | ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS | |
| D | 07.05.29 | ADD BEVEL TO FWD END; ADD DETAIL B | |



NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT ϕ

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BY ORDER

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